

U. S. NUCLEAR REGULATORY COMMISSION  
OFFICE OF INSPECTION AND ENFORCEMENT  
REGION IV

Report No. 99900347/80-01

Program No. 51300

Company: G&W Taylor-Bonney Division  
Taylor Forge Stainless  
Readington Road  
North Branch, New Jersey 08876

Inspection Conducted: June 2-4, 1980

Inspectors:

J. W. Sutton  
J. W. Sutton, Contractor Inspector  
Components Section I  
Vendor Inspection Branch

6-20-80  
Date

Approved by:

D. E. Whitesell  
D. E. Whitesell, Chief  
Components Section I  
Vendor Inspection Branch

06-20-80  
Date

Summary

Inspection on June 2-4, 1980 (99900347/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B and the applicable codes and standards, including review of QA manual, organization, NDE personnel qualifications calibration and review of vendors activities. The inspection involved eighteen (18) inspector-hours on site by one (1) NRC inspector.

Results: In the four (4) areas inspected no deviations or unresolved items were identified in three (3) areas. The following was identified in the remaining one (1) area.

Deviation: Calibration Control . . . . The calibration activities were not being performed in accordance with the procedures. (Enclosure, Item A).

Unresolved Items

None.

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DETAILS SECTIONA. Persons Contacted

\*M. B. Grohol, Quality Assurance Manager

\*C. E. Henry, Manufacturing Manager

M. W. ... ey, General Manager

\*Attended Exit Interview

B. QA Program Review (Organization - Program)1. Objectives

The objectives of this inspection were to ascertain whether the QA Program has been documented in writing, and if it is correctly implemented, and will ensure that the completed components will be manufactured in compliance with code requirements and meet the prescribed quality standards. Also, to ascertain whether the program is consistent with NRC regulations, contract, and code requirements.

2. Method of Accomplishment

- a. Review of G&W Taylor-Bonney (GWTB) QA manual, dated November 7, 1979.
- b. Review of appropriate organization charts to verify that the QA staff is independent from the pressures of cost and scheduling and has access to upper management.
- c. Review of the documents concerning the authority, duties, and responsibilities of the Quality Assurance staff, to verify that they have the independence to identify quality problems, and initiate appropriate corrective action, and the authority to stop work.
- d. Review of proposed training schedules and activities to date.

3. Findingsa. Deviations

None.

b. Unresolved Items

None.

c. General

The inspector brought to managements attention that the Company's statement of policy, did not indicate that the requirements of 10 CFR 50/45.2 criteria would be met by GWTB's QA Program. Management indicated that this item would be reviewed and appropriate action taken.

C. Nondestructive Examination (NDE) Personnel Qualifications1. Objective

The objective of this area of the inspection was to verify that NVD had implemented the requirements for the qualification and certification of NDE personnel in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of GWTB's QA manual, Section 6.0 Titled "Test and Non-destructive Examination" to verify that special processes are performed by qualified personnel using qualified procedures.
- b. Review of nine (9) NDE personnel qualification records.
- c. Review of SNT-TC-1A, 1975, "Personnel Qualification and Certification in Nondestructive Testing."
- d. Review of the NDE master list of NDE Personnel dated 11-1-79.
- e. Review of the Level III examiners qualification.
- f. Review of the following Process Specifications:
  - (1) S41.02 Revision 1, Radiography
  - (2) S41.03 - Liquid Penetrant inspection
  - (3) 41.310 - Revision 3, Penetrant
  - (4) 41.128 - Radiography
- g. Review of Penetrant, Cleaner and Developer certification for Batch No's 795030-80F002, and 79M0109.

h. Discussion with NDE examiners.

3. Findings

a. Deviations

None.

b. Unresolved Item

None.

c. General

The evidence reviewed demonstrated that special processes are being performed by qualified personnel, using qualified procedures, consistent with the regulations, Code, and contract commitments.

D. Calibration

1. Objectives

The objectives of this area of the inspection were to verify that:

- a. Calibration activities are performed and controlled in accordance with the QA Manual commitments and the applicable NRC regulations and ASME Code requirements.
- b. A system has been established, and is maintained, to assure that tools, gages, instruments, and other measuring devices used in activities affecting quality are properly calibrated and adjusted at specified periods to maintain accuracy within the specified limits.
- c. Calibration records are kept for each instrument indicating the calibration results.
- d. The calibration system is being properly implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA manual Section 7.0 Titled "Calibration and Control of measuring and Test Equipment," to verify that provisions have been established to assure that equipment requiring calibration had been identified, the calibration frequency

is specified, the calibration standards are identified, the traceability of standards is required, and a recall system is in effect.

- b. Review of the calibration interval criteria.
- c. Review of the QA manual, Section 4.6, "Receiving Inspection and Control of Material."
- d. Review of Procedure S42.31, dated November 6, 1979 Titled "Calibration of Measuring and Test Equipment," S-44.7 and S42.5.
- e. Review of the equipment calibration log Book.
- f. Review of certifications for all calibration standards.
- g. Review of calibration certification for fifteen (15) calibration instruments.
- h. Review of the recall system.
- i. Inspection of calibrated instruments in the shop.

### 3. Findings

#### a. Deviations

See enclosure item A.

#### b. Unresolved Items

None.

## E. Review of Vendor's Activities

### 1. Objectives

The objectives of this area of the inspection were:

- a. To review the nuclear activity and work load to assess their impact on future NRC inspections.
- b. Evaluate the vendor's fabrication/manufacturing equipment and capabilities.

### 2. Method of Accomplishment

The foregoing objectives were accomplished by observing manufacturing/fabrication in progress, and discussions with cognizant vendor personnel.

### 3. Findings

The vendor is a material manufacturer and supplier of stainless and alloy butt weld fittings and flanges from 1/2" thru 24" diameter. Their construction may be seamless, welded without filler metal, i.e. A-312, or resistance welded.

The vendor holds a valid ASME Certificate of Authorization NPT-1 57- for Class 1-2-3 piping subassemblies and Tubular Products welded with filler metal and Quality System Certificates 269 and 270 for manufacturer of ferrous seamless Tubular Products.

In-house capabilities include manual-semi and automatic welding, cold forming, heat treating, machining, liquid penetrant and radiographic examination as required to meet this product range. All shipping is done by truck from this facility. There is no access to rail shipping.

Approximately 30% of the total vendor's manufacturing activities represents the vendor's total commercial nuclear work load.

### F. Exit Interview

The inspector met with management representative (denoted in paragraph A) at the conclusion of the inspection. The inspector summarized the scope and findings of the inspection. The management representatives had no comment to response to the items discussed by the inspector.